

Work Order ID 149570

Monday, July 25, 2016 2:36:44 PM

149570

Page 1

Item ID: D3780-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest Assembly
 Start Date: 8/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/17/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: **AUG 02 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3780	Rev D								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- assemble as per dwg D3780 ****torque screws 25ft lbs****								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>SH454</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

Pick kit

DAS
6
9-89

SEP 16 2016

1

FF

SEP 19 2016

DAS
38
9-89

SEP 20 2016

1

SEP 20 2016

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
2015 01 14 14:32				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐					

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NS1

Stop ***NS2***

Customer:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

0.00

2m 16/09/21

DQA: _____ Date: _____



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OTHER : _____					

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Work Order ID: 149570

149570

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 8/15/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3696-041		Manufactured	No			100	Each	8.0000	1	1			DAS 9-89
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D3696-041

Arm Assembly

Location	Loc Qty	Loc Code
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ST457	8	
143631	8	

D3781-041		Manufactured	No			100	Each	10.0000	1	1			DAS 9-89
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D3781-041

Lateral Cushion Assembly

Location	Loc Qty	Loc Code
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ST458	10	
143634	10	

D3781-043		Manufactured	No			100	Each	4.0000	1	1			DAS 9-89
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	-------------

D3781-043

Armrest Cushion Assembly

Location	Loc Qty	Loc Code
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ST458	4	
143653	4	

D3785-3		Manufactured	No			100	Each	4.0000	1	1			DAS 9-89
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	-------------

D3785-3

Bracket

Location	Loc Qty	Loc Code
----------	---------	----------

ST458	4	
56903	4	

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DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				☐ OTHER : _____							

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Work Order ID: 149570

149570

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 8/15/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

D3977-1

Manufactured No

100

Each

2.0000

1

1

D3977-1

Bolt

150052

DAS
6
9-89

Location

Loc Qty

Loc Code

ST067

2

139539

2

D3978-1

Manufactured No

100

Each

3.0000

1

1

D3978-1

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

ST067

3

139521

3

D3979-1

Manufactured No

100

Each

20.0000

1

1

D3979-1

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST067

20

55183

20

NAS1149D0332J

Purchased No

100

Each

1,614.000

2

2

NAS1149D0332.J

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

546

m134848

546

GA

979

m135046

979

ST264

83

m134502

6

m134738

77

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Work Order ID: 149570

149570

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 8/15/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

AN970-6

Purchased

No

100

Each

67.0000

2

2

AN970-6

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

ST321

67

M134063

17

M135274

50

2

MS21042L3

Purchased

No

100

Each

2,283.000

2

2

MS21042L3

Nut

135407

DAS

6

9-89

Location

Loc Qty

Loc Code

CCK007

600

m135056

600

FP001

14

m133790

14

GA

571

m134360

112

m135135

459

OVER007

700

m135135

700

ST303

398

m134039

12

m134943

386

MS24665-302

Purchased

No

100

Each

32.0000

1

1

MS24665-302

Cotter Pin

135672

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

17

m134738

17

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Work Order ID: 149570

149570

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 8/15/2016

Required Date: 8/17/2016

Start Qty: 1.00

Required Qty: 1.00

MS24693-C272

Purchased

No

100

Each

1,018.000

2

2

MS24693-C272

Screw

Location

Loc Qty

Loc Code

OVER010

986

17137

467

17831

519

ST287

32

9370

32

MS24693-C277

Purchased

No

100

Each

80.0000

2

2

MS24693-C277

Screw

Location

Loc Qty

Loc Code

ST287

80

m128060

80

NAS1149D0663J

Purchased

No

100

Each

696.0000

1

1

NAS1149D0663.J

Washer

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST263

464

M135135

464

ST269

5

M126334

5

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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